IN THE CLAIMS

- 1. (Original) A process for making quetiapine comprising the step of reacting 11-piperazinyl dibenzo[b,f]-[1,4]thiazepine hydrochloride and 2-(2-chloroethoxy) ethanol in a solvent in the presence of a base, and a phase transfer catalyst.
- 2. (Original) The process of claim 1 wherein the reacting is at reflux temperature.
- 3. (Original) The process of claim 1 wherein the reacting is performed in the presence of an alkali metal halide.
- 4. (Original) The process of claim 3 wherein said alkali metal halide is sodium iodide.
- 5. (*Original*) The process of claim 1 wherein the phase transfer catalyst is selected from the group consisting of tetrabutylammonium bromide, triethylbenzylammonium chloride, tricaprylmethylammonium chloride and tetrabutylammonium hydroxide.
- 6. (Original) The process of claim 5 wherein the phase transfer catalyst is tetrabutylammonium bromide.
- 7. (Original) The process of claim 1 wherein the solvent is a lower alkanol, an aromatic hydrocarbon, or dipolar aprotic solvent, or a mixture of one or more of these.
- 8. (Original) The process of claim 7 wherein the solvent is *n*-butanol.
- 9. (Original) The process of claim 7 wherein the solvent is toluene.
- 10. (Original) The process of claim 7 wherein the solvent is dimethyl formamide.

- 11. (Original) The process of claim 1 wherein the base is selected from the group consisting of an alkali metal and alkaline earth metal oxides, hydroxides, bicarbonates and carbonates.
- 12. (Original) The process of claim 11, wherein said base is sodium carbonate.
- 13. (Original) A process for making quetiapine hemifumarate comprising the steps of:
- a) reacting 11-piperazinyl dibenzo[b,f]-[1,4]thiazeine hydrochloride and 2-(2-chloroethoxy)ethanol in a solvent in the presence of a base, and a phase transfer catalyst, whereby a first slurry is obtained,
- b) separating the solid from the first slurry whereby a liquid filtrate is obtained,
- c) combining the liquid filtrate with fumaric acid, whereby a second slurry is obtained, and
 - d) isolating quetiapine hemifumarate from the second slurry.
- 14. (*Original*) The process of claim 13 wherein the combination of step c) is heated to a temperature of about 80°C to about 100° C or higher and subsequently cooled to a temperature less than about 100° C, whereby a slurry is obtained.
- 15. (Original) The process of claim 13 wherein the reacting is at a temperature of about 100°C.
- 16. (*Original*) The process of claim 13 wherein the reacting is performed in the presence of an alkali metal halide.
- 17. (Original) The process of claim 16 wherein said alkali metal halide is sodium iodide.

- 18. (Original) The process of claim 13 wherein the phase transfer catalyst is selected from the group consisting of tetrabutylammonium bromide, triethylbenzylammonium chloride, tricaprylmethylammonium chloride, and tetrabutylammonium hydroxide.
- 19. (Original) The process of claim 18 wherein the phase transfer catalyst is tetrabutylammonium bromide.
- 20. (Original) The process of claim 13 wherein the solvent is a lower alkanol, an aromatic hydrocarbon, or dipolar aprotic solvent, or a mixture of one or more of these.
- 21. (Original) The process of claim 20 wherein the solvent is n-butanol.
- 22. (Original) The process of claim 20 wherein the solvent is toluene.
- 23. (Original) The process of claim 20 wherein the solvent is dimethyl formamide.
- 24. (*Original*) The process of claim 13 wherein the base is selected from the group consisting of an alkali metal and alkaline earth metal oxides, hydroxides, bicarbonates and carbonates.
- 25. (Original) The process of claim 24 wherein the base is sodium carbonate.
- 26. (Original) The process of claim 13 further comprising the step of recrystallizing the isolated quetiapine hemifumarate from a solvent selected from the lower alkanols and mixtures of a dipolar aprotic solvent and water.
- 27. (Currently Amended) The process of claim 26 wherein the lower alkanol is ethanol or isopropanol isopropanol and the dipolar aprotic solvent is dimethyl formamide.

- 28. (Original) In a process for making quetiapine or a pharmaceutically acceptable salt thereof, the step of reacting 11-piperazinyl dibenzo[b,f]-[1,4]thiazepine hydrochloride and 2-(2-chloroethoxy)ethanol in a solvent that is a lower alkanol, an aromatic hydrocarbon, or a dipolar aprotic solvent, in the presence of sodium carbonate, sodium iodide, and tetrabutylammonium bromide.
- 29. (Original) The process of claim 28 wherein the pharmaceutically acceptable salt is the hemifumarate.
- 30. (Original) A process for making quetiapine comprising the step of reacting, at reflux, 11-piperazinyl dibenzo[b,f]-[1,4]thiazepine hydrochloride and 2-(2-chloroethoxy)ethanol in a solvent selected from n-butanol, toluene, and dimethyl formamide, in the presence of sodium carbonate, sodium iodide, and tetrabutylammonium bromide.
- 31. (Original) A process for making quetiapine hemifumarate comprising the steps of:
- a) reacting, at reflux, 11-piperazinyl dibenzo[b,f]-[1,4]thiazapine hydrochloride and 2-(2-chloroethoxy)ethanol in a solvent selected from n-butanol, toluene, and dimethyl formamide in the presence of sodium carbonate, and tetrabutyl ammonium bromide, whereby a first slurry is obtained,
- b) separating the solid from the first slurry whereby a liquid filtrate is obtained,
 - c) combining the liquid filtrate with fumaric acid,
 - d) heating the combination to a temperature of about 100°C or higher,
- e) subsequently cooling the combination to $< 100^{\circ}$ C, whereby a second slurry is obtained, and
 - f) isolating quetiapine hemifumarate from the second slurry.
- 3132. (Currently Amended) The process of claim 30 31 wherein the rereacting reacting is carried-out also in the presence of sodium iodide.

- 3233. (Currently Amended) The process of claim 30 31 further comprising the step of recrystallizing the quetiapine hemifumarate isolated in step f) from a solvent selected from the lower alkanol or a mixture of a dipolar aprotic solvent and water.
- 3334. (Currently Amended) The process of claim 32 wherein the lower alkanol is ethanol or isopropanol and the dipolar aprotic solvent is dimethyl formamide.